

Work Order ID 141196

141196

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Monday, February 01, 2016 11:44:25 AM

Item ID: D2646BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Cap
 Start Date: 1/29/2016 Start Qty: 10.00 ***10*** 16 Cust Item ID:
 Required Date: 2/12/2016 Req'd Qty: 10.00 ***10*** 16 Customer:
 Reference:

Approvals: Process Plan: 34 Date: 20160201 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2646	Rev C								

150 Chemical Conversion Coat per QSI005 4.1 0.00

150

HandFinish

Hand Finishing

Memo

PULL FROM W/O 141214

16 X D2646

B 141214 (x16)

0.00

160

160

SprayPaint

Spray Painting

Memo

-PRIME B 134188

-SPRAY PAINT

BLUE DELFLEET B 134120

-DELFLEET CLEAR B 129058

0.00

0.00

x16 d 16/02/20

16 DAS 41 9-89 16-2-9

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N900040100

Setup Start *NS1*

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

170

0.00

DAS
38
9-89

MAR 01 2016

180

0.01

Install inserts as per Dwg D2646

0.00

190

0.00

Quality Control

DAS
38
9-89

MAR 02 2016

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.02							
Quality Control									

x16 d 16/03/02

ML5 MAR 07 2016

SA 160303

Picklist Print

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Work Order ID: 141196

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Parent Item: D2646BL

***D2646BL ***

Parent Item Name: Aft Cap

Start Date: 1/29/2016

Required Date: 2/12/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: G05.08.22Hole size revised in Step 5KJ/JLM
 IPP Rev:H Changed Inserts 07-02-19 JLM
 IPP rev I changed inserts 07.06.11 EC IPP REV:J
 15.10.09 ADDED BL DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130	AELS8-1032-130	Purchased	No			110	Each	2,630.000	2	20 32			
AI S7-1032-130									**				
Rivnut													

Location	Loc Qty	Loc Code
FG	100	
M128649	100	
FP001	1207	
M128649	1207	
st549	1323	
M128649	1323	

D2646 Manufactured No Each 50.0000

D2646

Aft Cap

Location	Loc Qty	Loc Code
FG	4	
85848	2	
90495	2	
FP001	46	
127924	1	
132326	1	
136885	44	

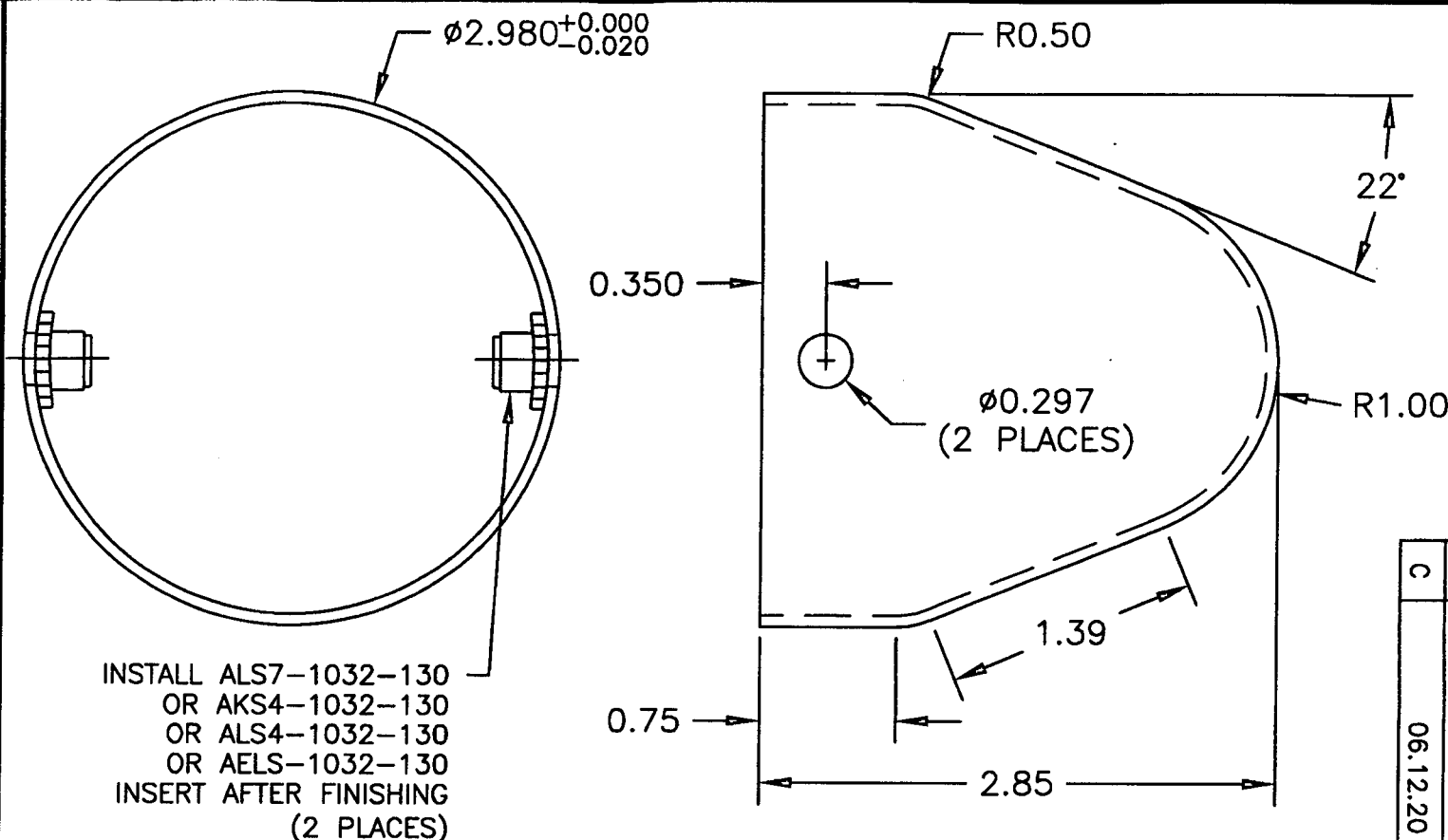
B141214

Handwritten notes and signatures:

- 32
- 16/03/03
- 18 16
- 16/03/02
- 16



DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1	
A		97.03.25	NEW ISSUE			
B		05.04.01	CHANGE TO CLOSED INSERTS			
C		06.12.20	CHANGE TO OPEN ENDED INSERTS			



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.12

20160125
SIA 14/196

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							